



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D3610-041
Job Sheet 194653



Part No: D3610-041

Job Qty: 10 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/7/19

Job Tracking No:

Due Date: 5/27/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3610 REV B IPP rev A new issue 07.03.28 EC IPP rev B released, changed mat'l EC IPP REV C:AS
PER REV B JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs	5/27/19	5/27/19	0.00	0.35	Bandsaw - 1	52 DAS 19/05/17	
110	HAAS 4 Axis - B4B	10 pcs	5/27/19	5/27/19	0.39	12.20	HAAS - 1 - B4B HAAS - 2 - B4B HAAS - 3 - B4B HAAS - 4 - B4B	52 DAS 19/05/17 9-89	
120	QC 2	10 pcs	5/27/19	5/27/19	0.00	0.00	QC 2 - 1 QC 2 - 12 QC 2 - 14 QC 2 - 17 QC 2 - 19 QC 2 - 2 QC 2 - 20 QC 2 - 22 QC 2 - 23 QC 2 - 25 QC 2 - 32 QC 2 - 33 QC 2 - 35 QC 2 - 39 QC 2 - 4 QC 2 - 40 QC 2 - 44 QC 2 - 45 QC 2 - 48 QC 2 - 49 QC 2 - 50 QC 2 - 51 QC 2 - 52 QC 2 - 57 QC 2 - 62	52 DAS 19/05/17 9-89	



Container No: S182309



Part: D3610-041

Job No: 194653

Serial No/Batch: S182309

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/17/19

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CANADA
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130 QC 8	10 pcs	5/27/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
140 Small Fab - 2 - B4B	10 pcs	5/27/19	0.00 0.41	QC 8 - 1 (A)	Kt-19-05-18
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				Small Fab - 1 - B4B	DAS 58 MAY 21 2019 9-89
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
150 QC 5	10 pcs	5/27/19	0.00 0.00	Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
160 Powdercoat - 3 Grey Sand - B4B	10 pcs	5/27/19	0.00 0.18	QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Powdercoat - 1 - B4B	DAS MAY 21 2019 40
				Powdercoat - 2 - B4B	BEB 19-05-23
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	

170 QC 3	10 pcs	5/27/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	DAS 30 MAY 23 2019 9-89
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
180 Small Fab - 3 - B4B	10 pcs	5/27/19	0.00 0.41	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	MAY 23 2019
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
190 QC 5	10 pcs	5/27/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS 40 MAY 24 2019 9-89
200 Packaging 3-1 - Stock - B4B	10 pcs	5/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS 28 9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 -	

				B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210	QC 21 - SA	10 pcs	5/27/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - (Bandsaw) Cut blank 7.900 " long Descriptions: 110 - (HAAS CNC Vertical Machine) 1- Mill as per Folio FA692 Rev: <u>B</u> & Dwg D3610 Rev: <u>B</u> 2-Deburr per dwg D3610 120 - QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check)					

MAY 27 2019

140 - (Small Fab) 1-C'SINK AS PER DWG D3610

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: 11:30 OVEN TEMPERATURE: 320°FINISH TIME: 12:00 M138839

170 - (QC3- Inspect Part Finish)

180 - (Small Fab) Rivet Nut Plate as per Dwg D3610

190 - (QC5- Inspect part completeness to step on W/O)

200 - (Identify as per dwg & Stock Location:_____)

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140N-B1.500X1.5000	4140 Steel Bar 1.50 X 1.50	6.5000 ft (.65 ea)	100-Bandsaw - 1	<u>M135997</u> <u>S055621</u>
MS20426AD3-4	Rivet	20 Ea (2 ea)	180-Small Fab - 3 - B4B	<u>M136444-2</u>
MS21075L3	Nut Plate	10 Ea (1 ea)	180-Small Fab - 3 - B4B	<u>S041081</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M4140N-B1.500X1.5000	7	10	0
180-Small Fab - 3 - B4B	MS20426AD3-4	20	2,529	0
	MS21075L3	10	702	0

Part Specifications

Specifications could not be found.

Plex 5/7/19 8:48 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	194653
Description: Plate		Part Number:	D3610-1
Inspection Dwg: D3610 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.250	✓		Ver	
0.250	+/-0.010	0.250	✓		Ver	
0.63	+/-0.030	0.620	✓		Ver	
7.75	+/-0.030	7.753	✓		H.G.	
4.25	+/-0.030	4.250	✓		H.G.	
2.677	+/-0.010	2.675	✓		Ver	
0.38	+/-0.030	0.375	✓		Ver	
Ø0.277	+0.006/-0.001	Ø0.278	✓		G.P.	
Ø0.201	+0.005/-0.001	Ø0.202	✓		G.P.	
Ø0.098	+0.004/-0.001	Ø0.098	✓		G.P.	
0.88	+/-0.030	0.880	✓		H.G.	
0.94 x 0.50	+/-0.030	0.935 x 0.499	✓		Ver	
0.250	+/-0.010	0.252	✓		Ver	
0.125 depth	+/-0.010	0.125	✓		D.G.	

Measured by: DAS 52	Audited by: Kt	Preliminary Approval:
Date: 9-89 19/05/16	Date: 19.05.18	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.21	New Issue P/O D3610-041	KJ/DD	
B	12.05.15	Dimensions updated per Dwg Rev B	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					